


Date: Thursday, 8/3/2006 8:10:18 AM  
 User: Chantal-Lavoie

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BUSHING
<b>Job Number</b> : 28087	
<b>Estimate Number</b> : 12497	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D26179
<b>This Issue</b> : 8/3/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2617 REV E
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : E preliminary
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 8/10/2006 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : _____	
<b>Comment</b> : Est A 06.07.25 New Issue KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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Comment: Qty.: 0.0420 f(s)/Unit Total: 0.4200 f(s)

Delrin Round Bar .50"

Material: Delrin Round Bar Ø0.500"

(M-DELIN-R0.500)

Identify as D2617

Batch: M101421

06/08/08 10

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA &amp; DWG D2617,

FOLIO REV: N/A

DWG REV: E

2-DEBURR AS REQUIRED

N/A Machined Manually

06/08/08 10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/08/08 10

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 06/08/09 10

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr break all unmarked sharp edges 0.005 to 0.010

06/08/08 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 8/3/2006 8:10:18 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 28087

Part Number: D26179

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BG 06.08.09 10

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 53

AS  
LB 06/08/14 (10)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



CL 06/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector


NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

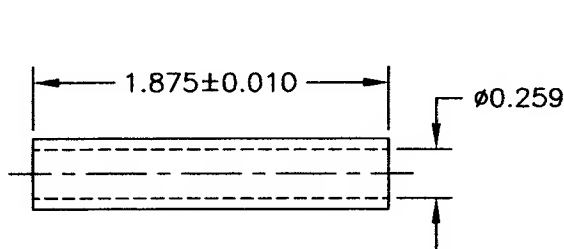
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

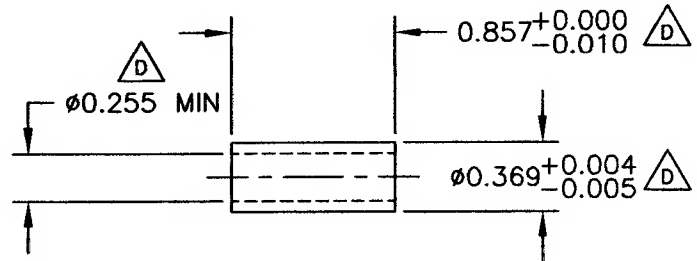
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# PRELIMINARY ISSUE

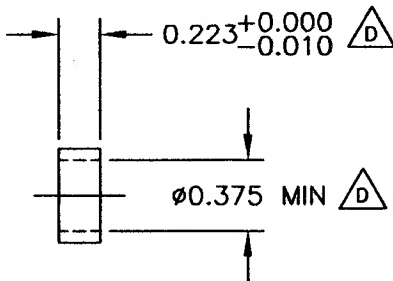
DESIGN BW	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2617	REV. E SHEET 1 OF 1
DATE 06.07.25	TITLE BUSHING SCALE 1:1		
A	96.10.08	NEW ISSUE	
B	97.05.08	0.875 WAS 1.125	
C	97.06.04	0.369 DIA WAS 0.375	
D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE CORRECT TOL. (NCR779), ADD D2617-7	
E	06.07.25	ADD D2617-9	



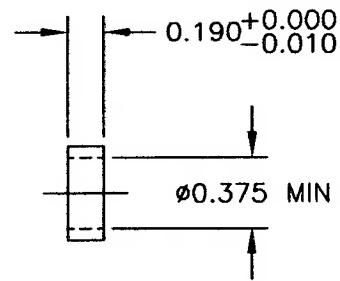
**D2617-1 (MAT'L SPEC: SEE NOTE 1)**



**D2617-3 (MAT'L SPEC: SEE NOTE 1)**  
**D2617-7 (DIM'S SAME AS D2617-3,  
FOR MAT'L SPEC: SEE NOTE 3)**



**D2617-5 (MAT'L SPEC: SEE NOTE 2)**



**D2617-9 (MAT'L SPEC: SEE NOTE 2)**

## NOTES:

- 1) MATERIAL FOR D2617-1/-3: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)  
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)  
(REF. DART SPEC. M5052H32R0.375)
- 2) MATERIAL FOR D2617-5/-9: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)  
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)  
(REF. DART SPEC. M5052H32R0.500)
- 3) MATERIAL FOR D2617-7: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-R0.375)
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD		Work Order:	28081
Description: Bushing		Part Number:	2617-9
Inspection Dwg: D2617 Rev: E		Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

## First Article

## Prototype

[illegible]

Measured by:		Audited by:	S.G	Prototype Approval:	
Date:	06/08/08	Date:	06/08/09	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	